

Work Order ID 67997

Tuesday, April 05, 2011 10:47:01 AM



Page 1

Item ID: D4380-21

Accept



Setup Start



Revision ID: PRELIM

Item Name: Cover, Small Hoist Control Panel

Stop



Start Date: 4/5/2011 Start Qty: 1.00

Required Date: 4/5/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: ME

Date: 11-04-05 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4380

PAGE 047 OK 11/04/05 ADJ

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

1

BP
11/04/05

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

Temp: 150° F

Time IN: 6:00 pm 11/04/04

Time OUT: 7:00 am 11/04/05

1

BP
11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA120 using tool DT9745

Dwg Rev: PA7
Folio Rev: A

0.00

0.00

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Visually inspect part for proper formation and texture

0.00

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

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Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Trim to finished dimensions as per Dwg

Dh
11/04/05

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

Dh
11/04/05

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

- inspect to Part
Done by
Sulayda (Signature)

W/O:		WORK ORDER CHANGES					
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Page 4

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Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: *FEAG 62*

0.00



Packaging

Memo

0.00

Packaging

11/4/12 ①

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16

MF 11-04-06

R 02370

POSITIVE RECALL

EFFECTIVE *11/21/13*

AUTH *11*

RELEASED *11/21/13*

DATE *11/25/13*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:46:58 AM

Page 1

Work Order ID: 67997

Parent Item: D4380-21

Parent Item Name: Cover, Small Hoist Control Panel



Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue. 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	3.46875			



6185 KYDEX .080"



Location

therm

Loc Qty

787.2912

Loc Code

787.2912

116576

3.46875

DL
11/04/06

LT

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 67997
Description: Small hoist control Panel Cover	Part Number: 04380 21
Inspection Dwg: D4380 Rev: PA2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4"</u>	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>OK</u>	Date: <u>11/04/05</u>
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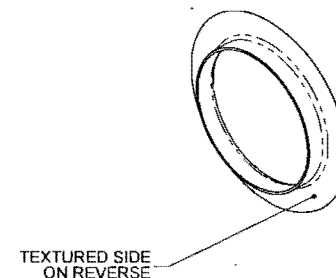
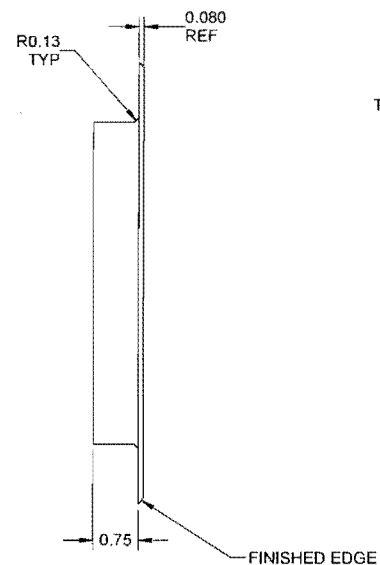
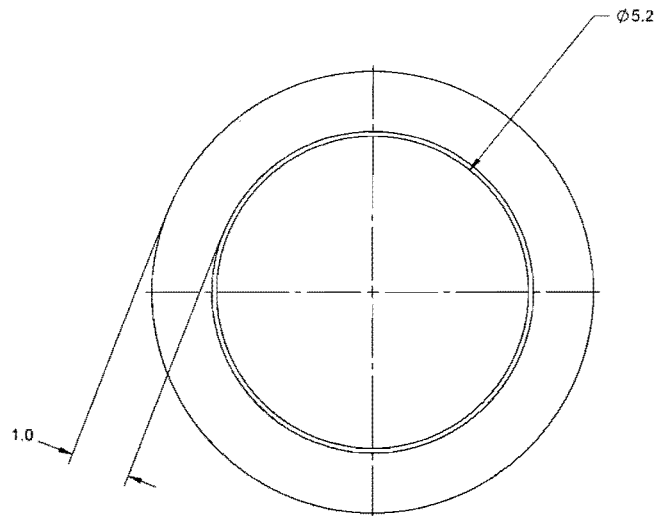
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>5.2"</u>	<u>±.100</u>	<u>5.176"</u>	✓		<u>Visual</u>	
<u>1.0"</u>	<u>±.100</u>	<u>1.04"</u>	✓		<u>Visual</u>	
<u>.75"</u>	<u>±.100</u>	<u>.76"</u>	✓		<u>Visual</u>	

Measured by: <u>OK</u>	Date: <u>11/04/05</u>
Audited by: <u>D to PA2 Dwg only</u>	Date: <u>11/04/06</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



D4380-21 COVER, SMALL HOIST CONTROL PANEL

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -21 PART PER MOULD DT9745.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE

DC 11.04.05

DESIGN	<i>DC</i>	DART AEROSPACE LTD	
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4380	SHEET 11 OF 19
APPROVED		TITLE	SCALE
DE APPR.		CEILING POCKETS	NTS
DATE	11.04.05	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED IN AND CANNOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Saturday, April 02, 2011 5:44 PM
To: 'Daryl Leger'
Cc: 'Eric Charbonneau'; 'JEANLUC MENARD'; 'Linda Lacelle'; Bill Beckett; 'Harvey Siemens';
'David Shepherd'
Subject: D4380 Issues

Hi Daryl,

Please see D4380-PA6 in the Prelim folder.

Fortunately, the guys were still here and I talked to them about the manufacturing issues.

Based on their feedback, I have modified the D4380-17 cover. It should be a little easier to manufacture.

However, the -3/-5/-27/-29 need to stay as they are. Please use the "cheat the corners" technique to make the part as true to the drawing as possible. There are spare air conditioning vents here – we could fedex you one on Monday if that would help in creating the moulds.

The only thing I changed in the PA6 rev was the -17.

As for cutting out the "tops" of the round parts (-21/-23/-25 etc), it is up to you. If you would like to cut it out and trim it, that's ok, or the guys here can do that.

Thanks Daryl,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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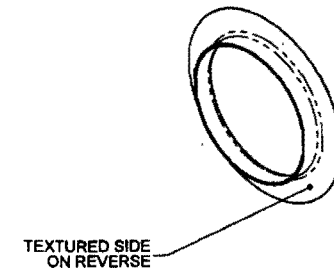
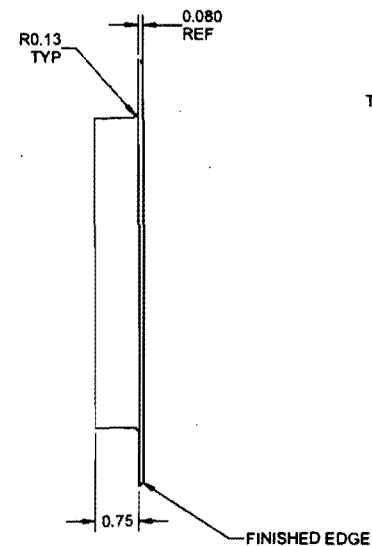
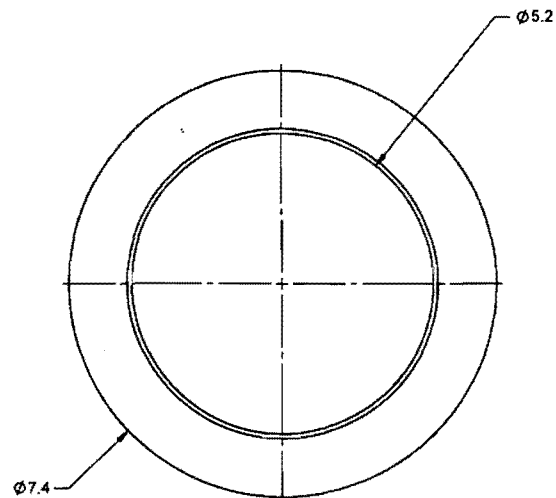
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- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.12 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOULD DT9745 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE

RELEASED
2011-05-10

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D4380	SHEET 11 OF 19
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CEILING POCKETS	NTS
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